

Date: Friday, 22/05/2009 8:59:26 AM
 User: Julie Dawson

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : AFT TUBE ASSEMBLY |
| Job Number : 48120 | |
| Estimate Number : 10699 | |
| P.O. Number : | Part Number : D3391025 |
| This Issue : 22/05/2009 S.O. No. : | Drawing Number : D3391 REV H |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 1/1 Type : SKIDTUBES | Drawing Revision : H |
| Previous Run : 47107 | Material : |
| Written By : | Due Date : 28/05/2009 |
| Checked & Approved By : <u>JLD 09.05.25</u> | Qty: 1 Um: Each |
| Comment : Est Rev B 06-02-07 ECN773 dwg rev. D EC | |
| Est Rev:C 06-03-28 Update Manuf. Instructions JLM | |

est rev D 07.03.20 revF dwg EC
 est rev E 07.11.07 rev G dwg ecn 1053p EC verified by:
 DD
 Est Rev:F 07-11-13 ECN 1056 DD verified by: EC
 Est Rev:G 08-09-10 revH as per dwg DD verified by:EC
 Est Rev:H 09-04-08 Added QC8 at Lathe as per NCR 09-028
 JLM Verified By:DD

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------|--------------------|
| 1.0 | D6014090 | ALUMINUM EXTRUSION |
|-----|----------|--------------------|



Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

| | | | |
|-----|-------------|-------------|---------|
| Qty | Part Number | Description | Batch |
| 1 | D6014-090 | Extrusion | B 42768 |

Identify as D3391-3

Q.M 09.06.020

| | | |
|-----|------------|----------------------------|
| 2.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
|-----|------------|----------------------------|

**Comment:** MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599 Rev: AA & Dwg D3391 Rev: H

Q.M 09.06.020

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Q.M 09.06.020

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D3391-025 PAR #: N/A Fault Category: Crosshatch NCR: Yes No DQA: ✓ Date: 09-08-20
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 07-08-27

| NCR: <u>48120</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | |
|---------------------|---------------|--|--------------------------------|--|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | | |
| 09/06/18 | 50 | One tube have a deviation On the dimension of 7.500 on one side. It was off by 1.33". | <u>QSI</u> 042 | STRUCTURALLY UNACCEPTABLE AND CANNOT BE REVERSED replace | 09-07-22 09/06/18 | <u>QSI</u> 042 | 09/07/27 |
| 09/06/18 | 50 | R.C. operator error Bad origin, lack of attention | <u>QSI</u> 042 | N.O. destrial | 09/06/18 | <u>QSI</u> 042 | 09/08-12 |
| | | | | | | | |

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 48120

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

1-Machine as per Folio FA 599 Rev: ____ & Dwg D3391 Rev: ____

2-Deburr

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

9.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .

*****Do Not Open To Finished Size*****

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 48120

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per Dwg D3391.

7-Deburr

Tools: rill

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

D36704200

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch: _____

16.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Instal spacers as per dwg D3391

A/R Magnabond 6398 Batch: _____

exp. date : _____

cure time 12hrs as per QSI0015

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Date: Friday, 22/05/2009 8:59:26 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 48120

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

20.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty

Part Number Description Batch

1

D2646

Aft Cap

21.0

D35371

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

22.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearpad

23.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Date: Friday, 22/05/2009 8:59:26 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 48120

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Gasket

25.0

D36721

Phenolic Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
PHENOLIC WASHER

26.0

ALS41032130

Insert



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)
INSERT
batch: _____
or equivalent per
QSI 017

27.0

ALS41032225

Insert



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
INSERT
or equivalent
Per QSI 017

28.0

AN3C4A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
Pick:
Qty Part Number Description Batch
2 AN3C4A Bolt

29.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt

5022

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT TUBE ASSEMBLY

Job Number: 48120

Part Number: D3391025

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|-----------|--------|
| 30.0 | AN960C10L | washer |
|------|-----------|--------|



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Inventory

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 2 | AN960C10L | Washer | |

| | | |
|------|-----------------|----------------------------|
| 31.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|------|-----------------|----------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/ R Sikaflex-241/-291

Sikaflex expiry date:

| | | |
|------|-----|------------------------------|
| 32.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|------|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

| | | |
|------|-------------|-----------------------|
| 33.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|------|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

| | | |
|------|------|------------------------------|
| 34.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|------|------|------------------------------|



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-08-19

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|--|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 128120 |
| Description: Float Skidtube (412) | | Part Number: D3391-3 |
| Inspection Dwg: D3391 | Rev: H | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

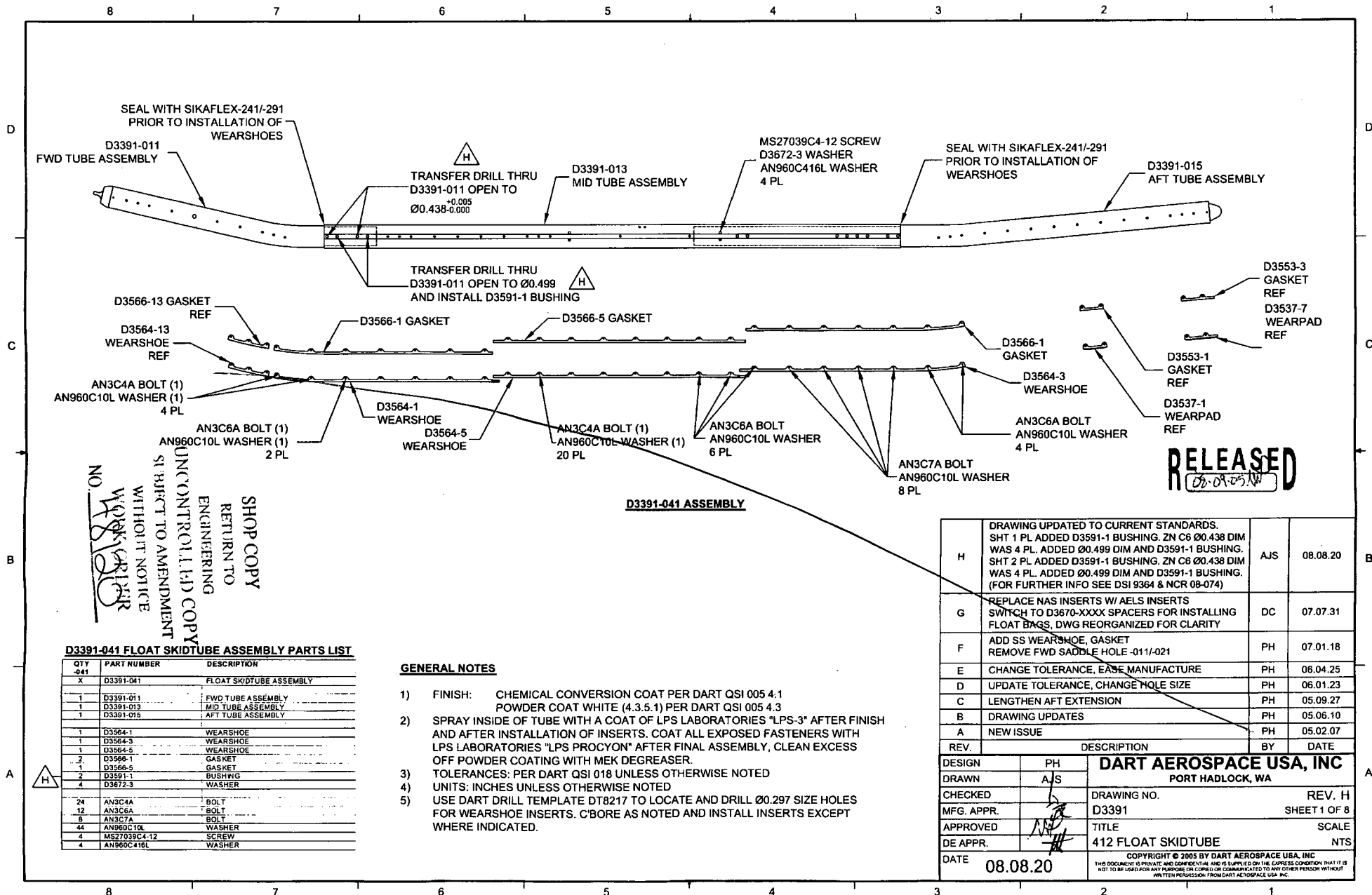
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|--------------------|-----------|------------------|--------|--------|----------------------|----------|
| Lathe Section | | | | | | |
| 14.000 | +/-0.010 | 14.010 | / | | | |
| 3.500 | +/-0.010 | 3.499 | / | | | |
| 88.93 | +/-0.030 | 88.945 | / | | | |
| 44.995 | +/-0.030 | 44.995 | / | | | |
| Ø3.200 | +/-0.010 | 3.199 | / | | | |
| 88.93 | +/-0.030 | 88.945 | / | | | |
| Ø3.750 | +/-0.010 | 3.750 | / | | | |
| 30° x 160" chamfer | +/-0.010 | | | | | |

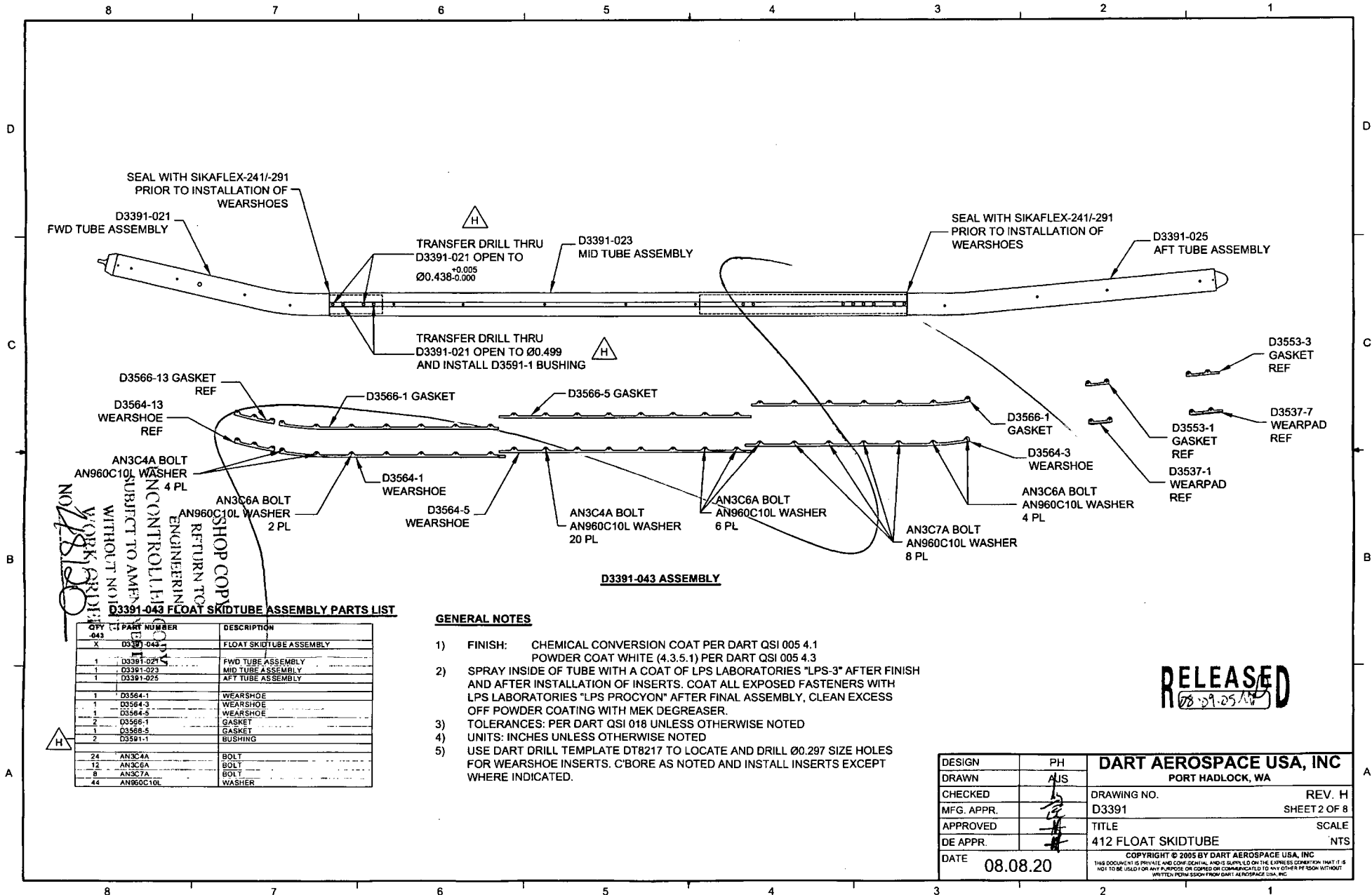
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|---------------------|--------------|
| Measured by: | Date: |
| Audited by: | Date: |

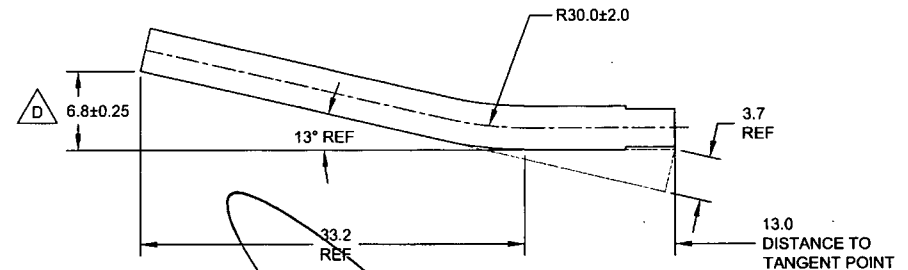
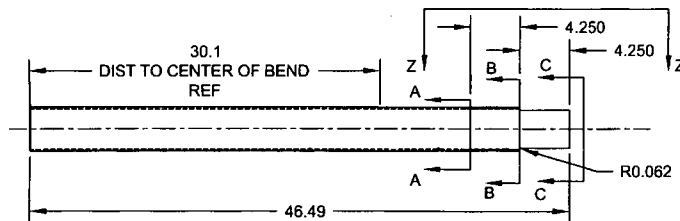
| | | | | | | |
|--------------|---------------|--|--|--|--|--|
| HAAS Section | | | | | | |
| 1.526 | +0.000/-0.030 | | | | | |
| 0.200 | +/-0.010 | | | | | |
| 7.500 | +/-0.010 | | | | | |
| 27.750 | +/-0.010 | | | | | |
| 31.750 | +/-0.010 | | | | | |
| 35.250 | +/-0.010 | | | | | |
| 3.300 | +/-0.010 | | | | | |
| 0.200 | +/-0.010 | | | | | |
| 3.520 | +/-0.010 | | | | | |
| 0.687 | +0.010/-0.000 | | | | | |
| R0.062 | +/-0.010 | | | | | |
| Ø0.484 | +0.005/-0.001 | | | | | |

| | |
|-------------------------|-----------------------|
| Measured by: Q.m | Date: 09.06.02 |
| Audited by: | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--|------------|----------|
| A | 06.04.24 | New Issue P/O D3391-015/-025 | KJ/JLM | |
| B | 06.06.19 | Dwg revision update | KJ/JLM | |
| C | 07.04.20 | Ø0.208 dimension removed | KJ/JLM | |
| D | 07.09.06 | 0.400 dimension removed | KJ/JLM | |
| E | 07.11.23 | Dwg Rev. updated | KJ/EC/DD | |
| F | 09.04.27 | Dimensions updated per Rev H and NCR09-028 | KJ/JLM | |

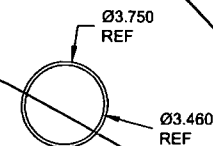




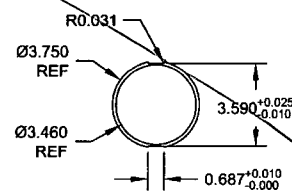


D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

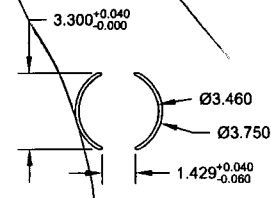
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



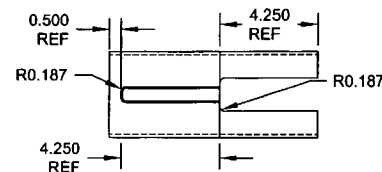
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SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

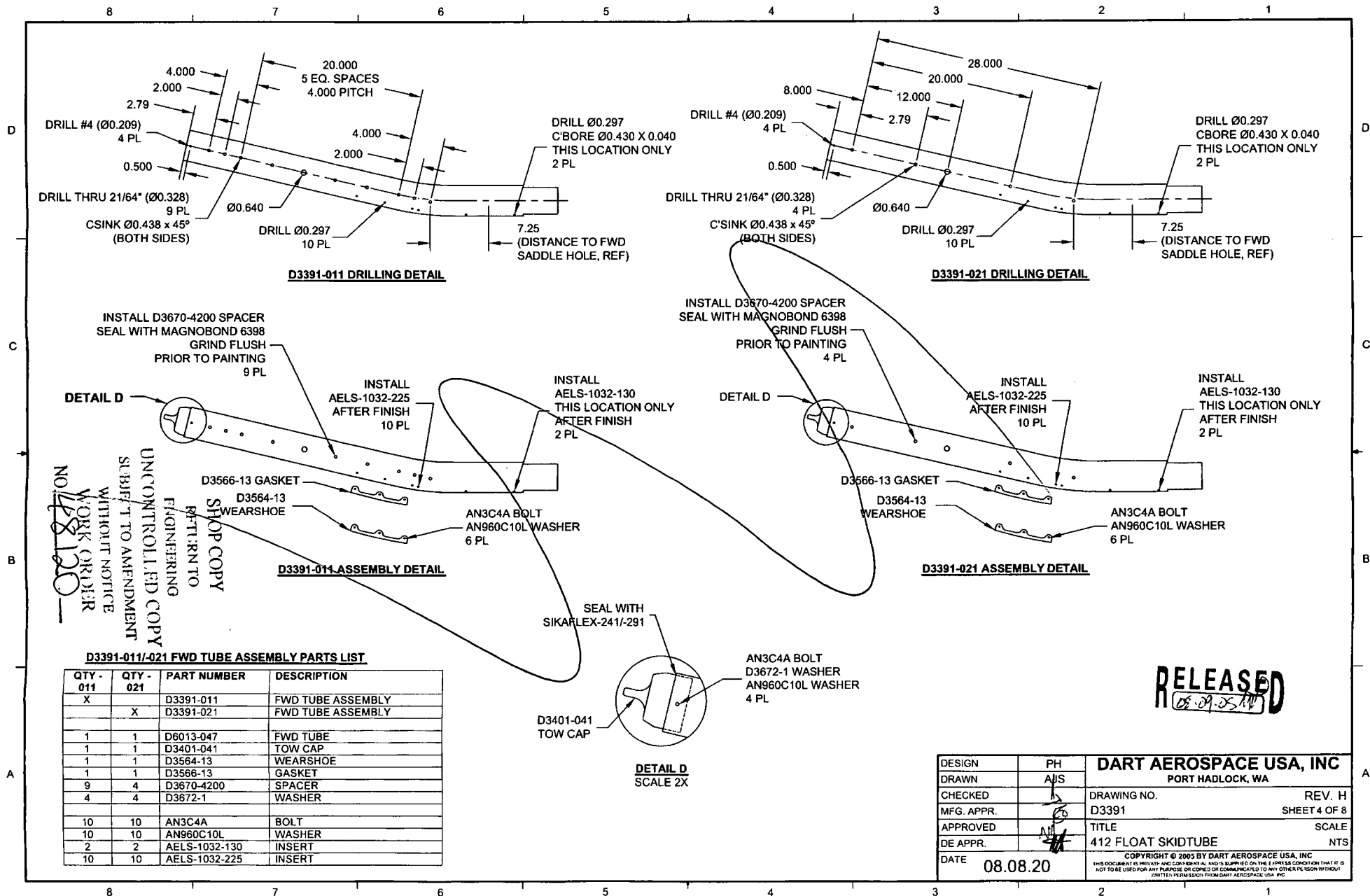


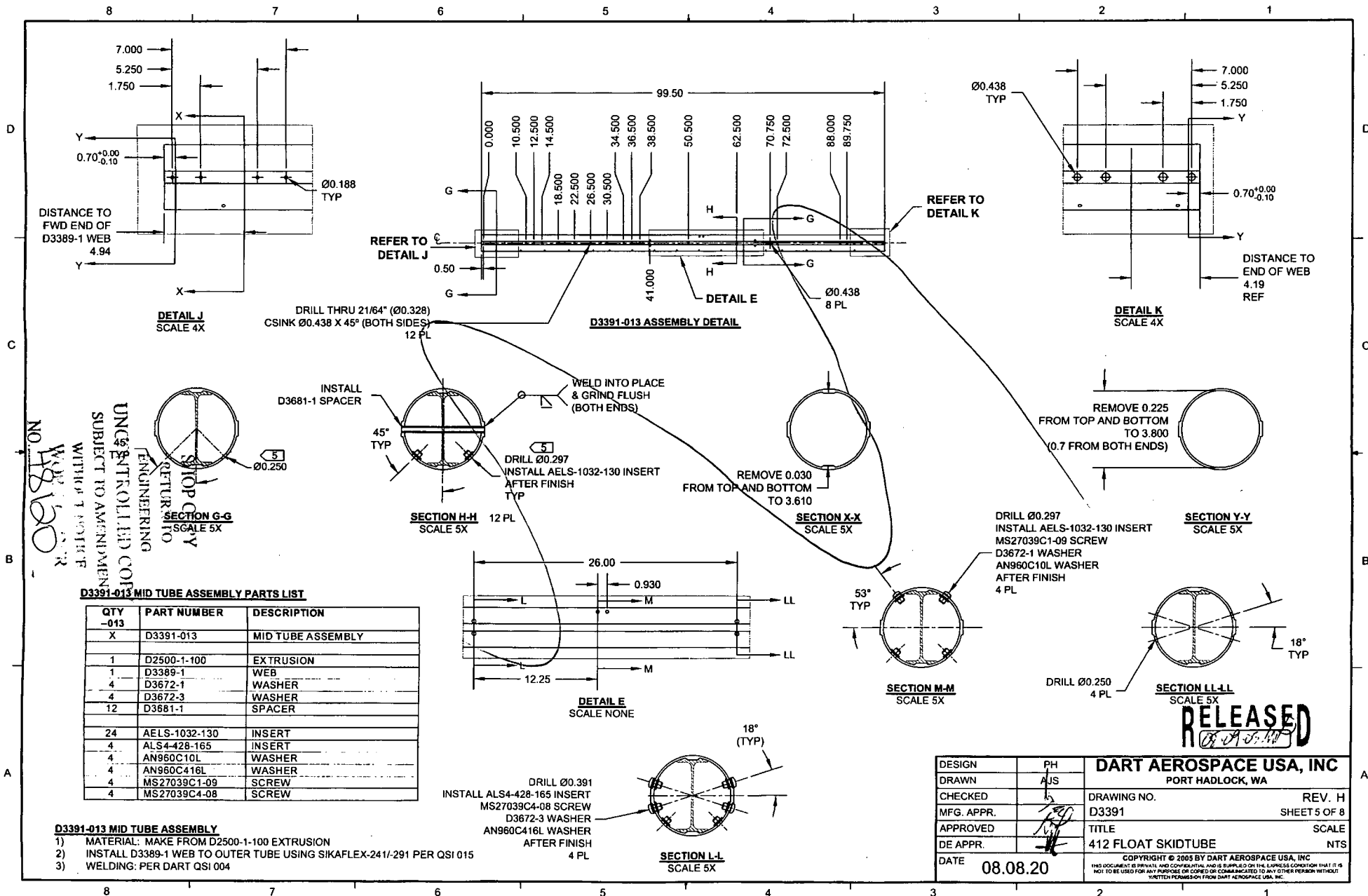
VIEW Z-Z
SCALE 2X

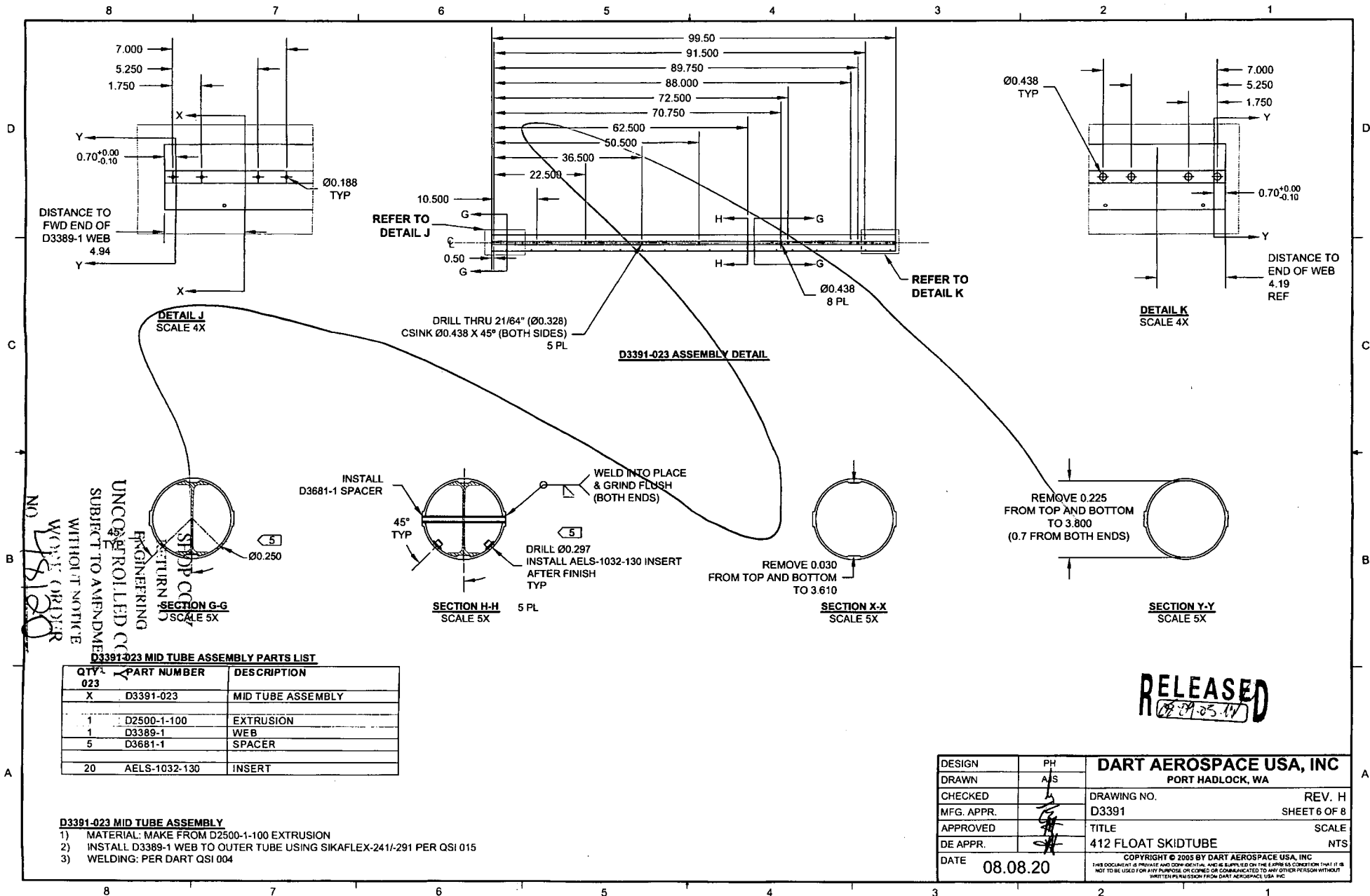
RELEASED
08-05-11

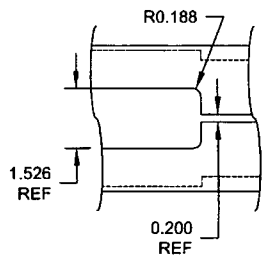
| | | | |
|------------|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. H |
| MFG. APPR. | | D3391 | SHEET 3 OF 8 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 412 FLOAT SKIDTUBE | NTS |
| DATE | 08.08.20 | <small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48100

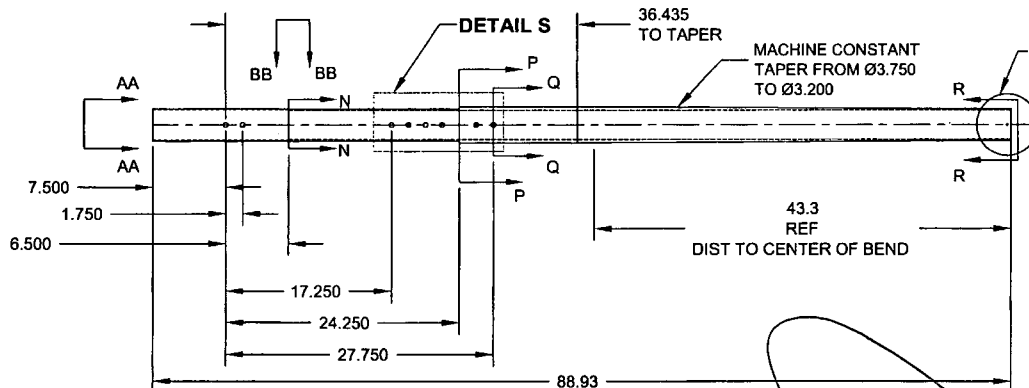




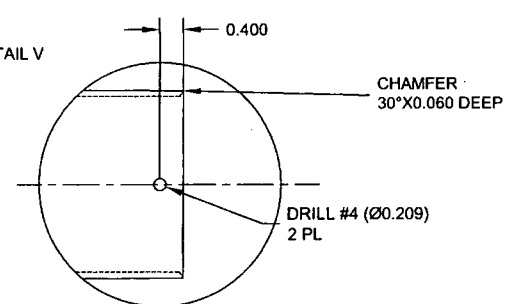




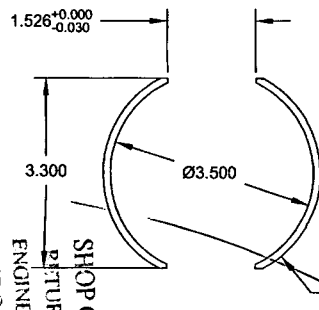
VIEW BB-BB
SCALE 4X



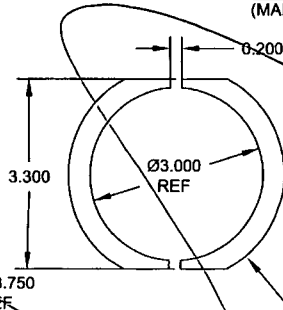
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



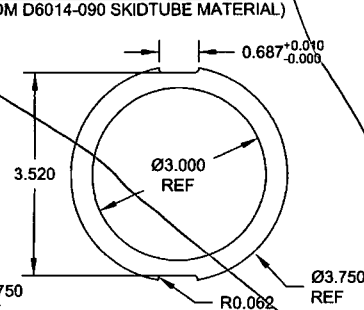
DETAIL V
SCALE 6X



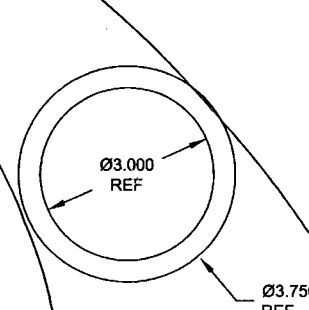
SECTION AA-AA
SCALE 6X



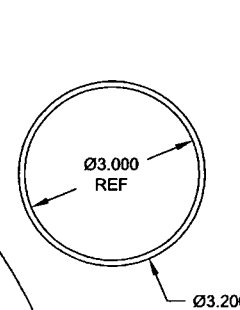
SECTION N-N
SCALE 6X



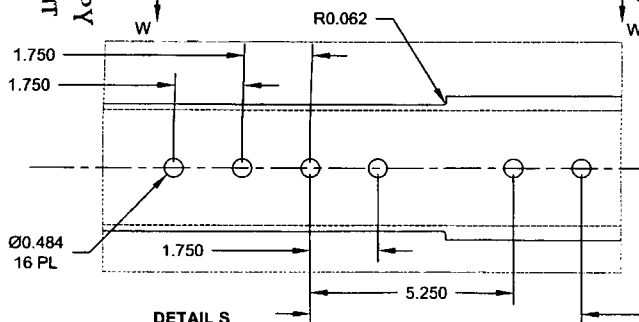
SECTION P-P
SCALE 6X



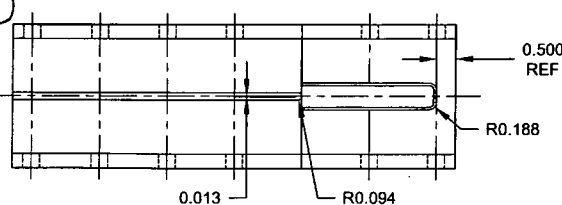
SECTION Q-Q
SCALE 6X



SECTION R-R
SCALE 6X



DETAIL S
SCALE 4X



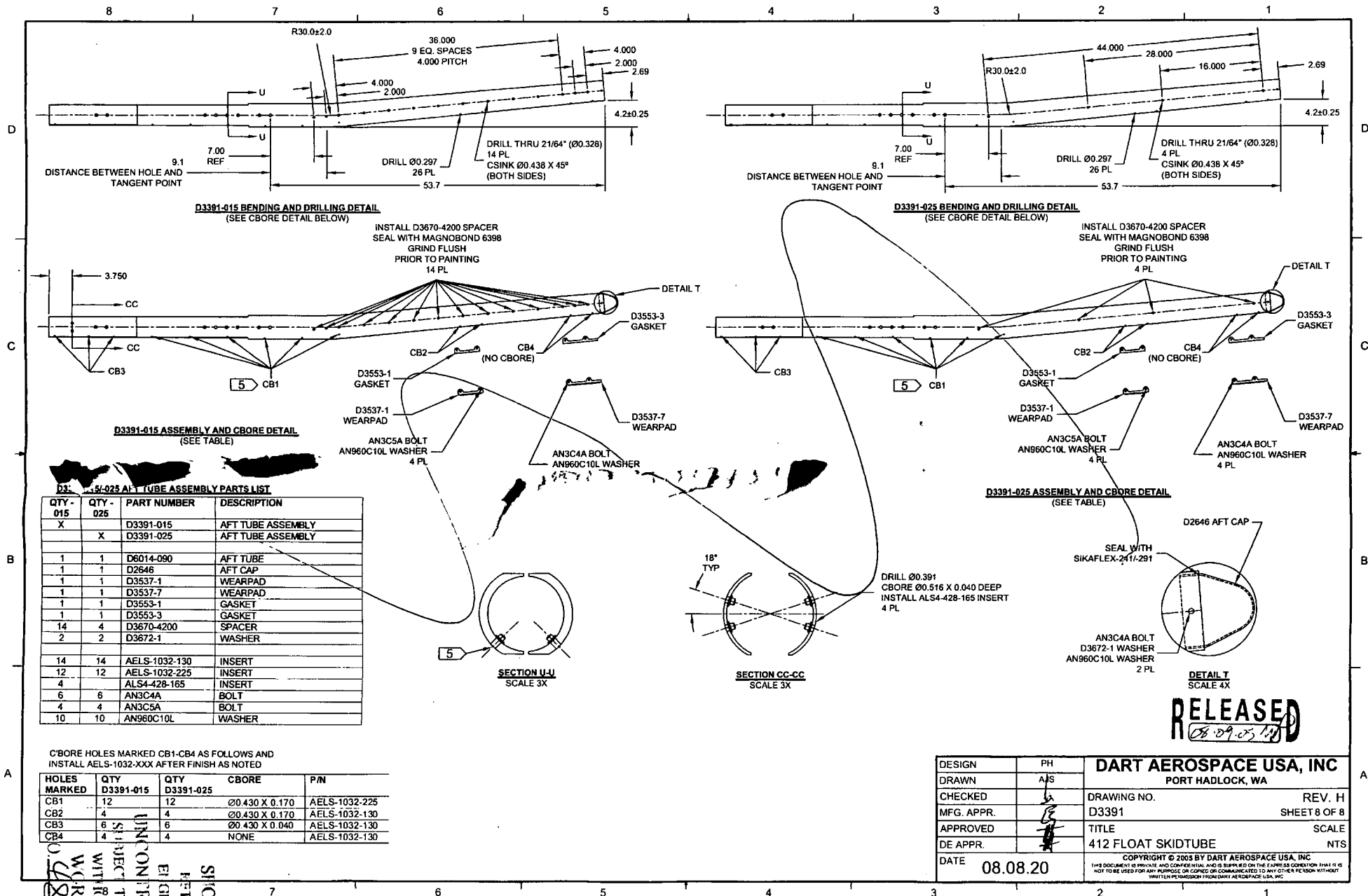
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| MFG. APPR. | | D3391 | SHEET 7 OF 8 |
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| DE APPR. | | 412 FLOAT SKIDTUBE | NTS |
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CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

| HOLES MARKED | QTY D3391-015 | QTY D3391-025 | CBORE | P/N |
|--------------|---------------|---------------|----------------|---------------|
| CB1 | 12 | 12 | Ø0.430 X 0.170 | AELS-1032-225 |
| CB2 | 4 | 4 | Ø0.430 X 0.170 | AELS-1032-130 |
| CB3 | 6 | 6 | Ø0.430 X 0.040 | AELS-1032-130 |
| CB4 | 4 | 4 | NONE | AELS-1032-130 |

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